	· ID 122309 2014 1:55:37 PM		*122				Page 1			
Revision ID: tem Name: B	73542-1 racket		Accept	*N900		100)*	Setup Star Stoj	1.71	S1* S2*
	714/14 Start Qty: 8.00	*8*		Cust Item	ID:					
Required Date: 7/ Reference:	/14/14 Req'd Qty: 8.00	*8*		Customer:			_			
Approvals: I	Process Plan: MI	Date: 14077	Tooling:	D	ate:		ŀ	Run Star	"171	R1*
•	QC:	Date:	SPC (Y/N):	* D	ate:			Stop	, *N	R2*
Sequence ID/ Work Center ID	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3542	Rev A									
*1 \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	BAND SAW Memo		0.00				Š	Ø		MH 14/67/s
easpa Bandsaw	Cut blank	4.0" long		· • · · · · · · · · · · · · · · · · · ·		•				
110 *110* HAAS 1	Memo	AL MACHINING #1	0.00			* .		_Ø_		/14/08/08
HAAS CNC vertical m	per dwg I		_	<u></u>						÷
120	QC2- Inspect parts of	f machine FAI/FAIB	0.00					ŕ		1,10
120		**************************************	No. of the second			•	8	Ø		14/08/06
QC	Memo		0.00							/ 1/2 43

Quality Control

DQA:		Date:			້າΔRT								
į				•	WORK ORDER NON-	-CC	ONFO	RMANCE / UPD	DATE			AEROSPACE	
QA Closed:		Date:							W	ork Order up	date only		
Work Orde	r.				DISPOSITION				·				
WOIK OIGE	·				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	о.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	0				Suspected Unapproved			Large Fab	Composite		Supplier		
Root	Root D		Desc	ription of work order update	Ī	nitial	Actio	n	Sign &		·		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector	
Design	_												
Doc/Data	_												
quip/Tooling	_												
landling/Pre				}									
Material													
Operator	_												
Offset/Setup	_		 ,		•								
Process			1						•				
Supplier	_												
Fraining	_					Ì							
Transport .				ŀ									
Jnapproved				<u></u>		EAL	III T CA	L TEGORY			L		
1						FA	OLI CA	IEGORI			<u></u>		
Landir	ng Gear Bendir	a			General Bend]Folio/	Program	Γ	Outside Dim	ensions	Pressure/Forced	
ŀ	—	ಕ Not Conce	ntric	-	BOM/Route	-	Grain	rogram	-	Over/Under	⊢	Set-up	
}	Cracks	Not conce	intric		Broken/Damage/Defect		Hardwa	are	-	Part Incorre	_	Temperature/Cure	
}	_	Kink/Rinnl	e/Mave		Burrs		-	ion Incomplete/Unq	ualified	Part Lost/Mi	<u> </u>	Weld	
•	Crimp/Kink/Ripple/Wave Burrs Cuffs Contamination			4 .	tions Incomplete/Un		Part Moved	Ť	Wrong Stock Pulled				
ļ	Crushi	าย			Countersink	\vdash		gned/off center		Positioned V	∟ Vrong	- ,	
			Cut Too Short		Mislab	-	T	Power Loss/		Other			
			Drawing		Misrea		_						
Marks/Chatter Drill Holes				Off-set			· · · · · · · · · · · · · · · · · · ·						
			Finish		Out of Calibration								
Wave/Twist in Tube				Fit/Function		Out of	Sequence						

Work Ord Monday, July 1				*122309*									Page
tem ID: Revision ID: Item Name:	D3542-1 Bracket			Accept	*	1900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*			Cust Item I Customer:	D:					ı W.	12
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):			ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center I	ID .	Operation Description	10.20	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
*130 *130* QC Quality Control		QC8- Inspect parts - sec Memo	ond check	0.00	م. در	14/08	3/04		8		4		DAS 08 9-89
140		Chemical Conversion C	oat per QSI005 4.1	0.00					~				
140 HandFinish Hand Finishing		Мето		0.00							1407/4	l-9-7	

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150 Powdercoat

Memo

0.00

Powder Coating

*****ENSURE TO MASK INSIDE BORE****START TIME:

1200 OVEN TEMPERATURE:

12.30 FINISH

CN 14-08-18

DQA:		_ Date:											
					WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE				AEROSPACE	
QA Closed:		Date:							W	ork Order up	odate only		
Work Orde	r:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
Work Orac				_	Rework		Skid-tube Crosstube			1	Water Jet	Engineering	
Part N	Part No.				Scrap			Machining Small Fal	_	Pro	d. Eng. Coor.	Quality	
				_	Use-as-is			noforming Finishin	g	Rec/Sto	re/Packaging	Other	
NCR N	0.				Suspected Unapproved			Large Fab Composite	e 🗀]	Supplier		
								,					
Root	De		Desci	ription of work order update		nitial	Action		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design	_												
Doc/Data													
Equip/Tooling	_												
Handling/Pre													
Material 🧧		1									ļ		
Operator													
Offset/Setup	_												
Process	_												
Supplier	_												
Training			1										
Transport	_	1											
Unapproved		<u>. l</u>	<u>. </u>	<u></u>		ΕΛΙ	III T CA	TEGORY		,	<u> </u>		
Landin	g Gear				General	17	OLI CA	TEGORI			 -		
	Bending				Bend	Г] Folio/I	Program		Outside Dim	nensions [Pressure/Forced	
-		lot Conce	ntric	-	BOM/Route	\vdash	Grain			Over/Under	 	Set-up	
-	Cracks	.00 00.100			Broken/Damage/Defect		Hardw	are		Part Incorre	<u> </u>	Temperature/Cure	
<u> </u>		ink/Ripple	e/Wave		Burrs	_	4	ion Incomplete/Unqualified		Part Lost/M	issing	Weld	
<u> </u>			Contamination		4 `	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
ļ	Crushing Countersink			 	4 .	gned/off center		Positioned \	Wrong				
ļ	Heat Treat Cut Too Short				Г	Mislab			Power Loss/	/Surge	Other		
Inspection Strip in Tube Drawing				Misrea	d								
Ţ	Marks/Chatter Drill Holes				Off-set								
Ţ	Turning Sequence Finish			Out of Calibration									
Wave/Twist in Tube				Fit/Function		Out of Sequence							

Work Orde Monday, July 14			*122309*									Page 3
Item ID: Revision ID:	D3542-1			Accept	*N900	<u>040</u>	100)*	Setup S	tart Stop		S1*
Item Name: Start Date: Required Date: Reference:	Bracket 7/14/14 : 7/14/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item 1 Customer:	ID:			ŭ	мор	*N:	S2*
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:]		tart Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
1 AN QC Quality Control		QC3- Inspect Part Finish Memo		0.00				8				DAS 38 9-89 /4/02
170 *17 Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: 570	0.00 0.00				-8x	, D	AS 2 8 3-89	A	UG 1 5 2014
180 *1 20 *		QC21- Final Inspection -	Work Order Release	0.00				_M_	2	14-	-08	<u> </u>

Memo

Quality Control

MLJ 14-08-18

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOR	RIVIAINCE / UI		Woı	k Order up	date only	AEROSPACE
Marila Orala					DISPOSITION		•		AGAINST I	DEP	ARTMENT/	PROCESS	
Work Orde Part N	Part No.				Rework Scrap		Skid-tube Crosstube Machining Small Fab					Water Jet	Engineering Quality
NCR N	0				Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other
Root				Desci	ription of work order update	i	nitial	Act	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	QC Inspector
Design Doc/Data													
Equip/Tooling				}									
dandling/Pre													
Material													:
Operator													
Offset/Setup													
Process													
Supplier		ļ											
Fraining						1							
Transport –	alia												
Jnapproved													
	······	 -	.4	1		FAI	ULT CA	regory					
Landir	ng Gear				General				_				
	Bending				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
. [Centre No	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
Ì	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorrec	ci 📗	Temperature/Cure
Ì	Crimp/Kir	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination	. ⊢ ⊢			Unclear		Part Moved		Wrong Stock Pulled
ļ	Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong	
	Heat Treat Cut Too Short					'Mislabe	eled			Power Loss/	Surge	Other	
	Inspection Strip in Tube Drawing						Misread						
	Marks/Chatter Drill Holes					Off-set							
							Out of	Calibration	*.	-			
Turning Sequence Finish Wave/Twist in Tube Fit/Function							Out of	Sequence					

Monday, July 14, 2014 1:55:36 PM

Work Order ID: 122309

122309

Parent Item:

D3542-1

D3542-1

Parent Item Name:

Bracket

Start Date: 7/14/14

Required Date: 7/14/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev: A New Issue

07-04-23

JLM

IPP Rev: B updated powder coat per NCR 07.05.16

EC

M126075

Component Item ID/ Item Name

Replacement Mfg/ **Item ID** Purch

Primary Bin Item Location

Last Location

Route Seq ID

Unit of Measure Hand

Qty on

Qty per Kit Total

Qty

Qty

Issued

Date **Issued**

Status

M6061T6B30000X01.5

Purchased

No

100

f

10.0000

0.3333333

**

2.666666

M6061T6B30000X01 500

6061-T6 Bar 3.00 x 1.50

Location MAT004

Loc Oty 10 10 Loc Code

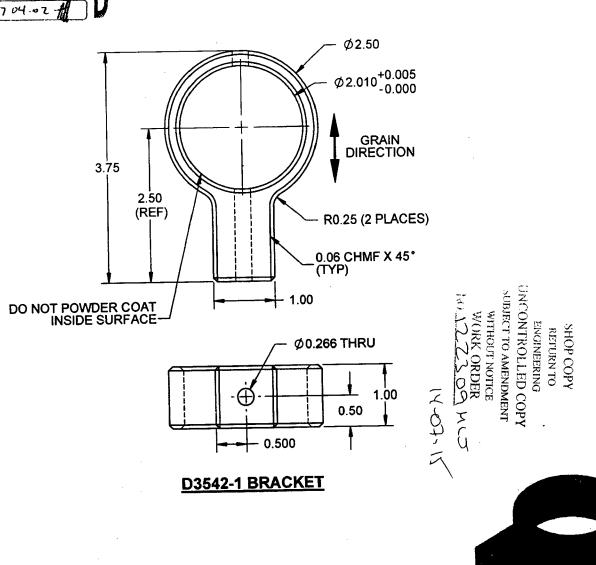
DQA:		 	Date:										
						WORK ORDER NON	l-CC	ONFO	RMANCE / L		ork Order up	udata anly - [AEROSPACE
QA Closed:			Date:		-				· · · · · · · · · · · · · · · · · · ·	V	ork Order up	date only	
Work Ord	er.					DISPOSITION	DISPOSITION AGAINST DEPARTM					PROCESS	
Work Ord	٠,.,					Rework	7		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part I	Part No.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
		,		****		Use-as-is	1		noforming	Finishing		e/Packaging	Other
NCR I	No.					Suspected Unapproved	1		Large Fab	Composite		Supplier	
<u> </u>													
Root					Desc	ription of work order update		nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design													· ·
Doc/Data													
Equip/Tooling	Щ												
Handling/Pre	Ш												
Material	Ш				Į								
Operator													
Offset/Setup									İ				
Process	igspace						1				}		
Supplier													
Training													:
Transport	\vdash		Ì										
Unapproved					<u> </u>				<u> </u>		_l	<u> </u>	
							FA	ULI CA	TEGORY				
Landi	ing (1				General		احمانه اد	Program	Г	Outside Dim	ensions [Pressure/Forced
	\vdash	Bending			-	Bend BOM/Route	-	Grain	rogram	<u> </u>	Over/Under	F	Set-up
		Centre No	ot Concer	itric	-	<u> </u>	\vdash	Hardwa	aro.	-	Part Incorre	ŀ	Temperature/Cure
	Cracks Broken/Damage/Defect				\vdash	4	ion Incomplete/	Inqualified	Part Lost/Mi	}	Weld		
	Crimp/Kink/Ripple/Wave Burrs Cuffs Contamination				-	1	tions Incomplete	· ·	Part Moved	h	Wrong Stock Pulled		
	\vdash	Crushing			-	Countersink	\vdash	4	gned/off center	<u> </u>	Positioned V	-	
	<u> </u>	Heat Trea	ıt.		\vdash	Cut Too Short	Mislabeled			.	Power Loss/	- r	Other
.:		1		Tube		Drawing	-	Misrea		1_		· U	
	Inspection Strip in Tube Drawing Marks/Chatter Drill Holes				\vdash	Off-set							
		Turning S			一	Finish	Out of Calibration				***************************************		
: :		Wave/Tw				Fit/Function		4	Sequence				

DART AEROSPACE LTD	Work Order:	122509
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542 Rev: A		Page 1 of 1

	Х	First Ar	ticle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comm	nents
Ø2.010	+0.005/-0.000	2,013			MJP-03	mic	
Ø2.50	+0.012/-0.001	2 499			MJP-04	VIV	· <i>N</i>
3.75	+/-0.030						
2.50	+/-0.010	2,497	/				
1.00	+/-0.010	3,747 2,497 1,000					
0.06 x 45°	+/-0.030 x 0.5°	0,060	/		V		
Ø0.266	+0.006/-0.001	0 271	/			gauge	pin
1.00	+/-0.030	1,000	/		MJP-OY	Ver	<u> </u>
0.50	+/-0.030		/				
0.500	+/-0.010	0,497	/		1	₩	,
easured by: Date:		Audited b	y: B.A e: 14 08	DAS 08 06 9-89	Prototype A	pproval: Date:	N/A N/A



DESIG	V	DRAWN BY		AEROSPACE LTD BURY, ONTARIO, CANADA
CHECK	ED	APPROVED	DRAWING NO.	REV. A
	h	1	D3542	SHEET 1 OF 1
DATE	-4	1	TITLE	SCALE
	06.	11.27	BRACKET	2:3
REV		DATE		DESCRIPTION
INE V		06 11 27	NEW ISSUE	



1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

2) FINISH. CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2006 BY DART AEROSPACE LTD